

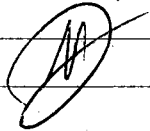
Work Order ID 156011

Friday, January 20, 2017 4:13:37 PM

156011

Page 1

Item ID: D2500-1-190 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ext'n - I' Beam Tube 4"
Start Date: 1/20/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/27/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: SCRAPPED

Approvals: Process Plan:  Date: JAN 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2500	Rev H								

105

0.00

105

Skidtubes

Skidtubes

Memo

PULL FROM STOCK
D2500-1-190 X10
B: 145247

SCRAP AND DESTROY
SMALL KINKS WERE FOUND
DURING PRODCUTION

SCRAP

0.00

140

QC21- Final Inspection - Work Order Release 0.00

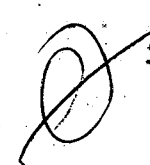
140

QC

Quality Control

Memo

0.17

 W1 70725

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work-Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, January 20, 2017 4:13:53 PM

Page 1

Work Order ID: 156011

156011

Parent Item: D2500-1-190

D2500-1-190

Parent Item Name: Ext'n -I' Beam Tube 4"

Start Date: 1/20/2017

Required Date: 1/27/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: G 02.09.05 Added DSK 066 KJ/RF
IPP: H 07.07.06 rev G dwg EC IPP Rev:I as per
dwg revH DD 10.02.23 verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190		Manufactured	No				Each	76.0000		10			
D2500-1-190									**			JAN 20 2017	
Ext'n -I' Beam Tube 4"													

Location

Loc Qty

Loc Code

HALL

76

151612

76

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

Work Order Summary

Tuesday, July 25, 2017 9:04:34 AM

Page 1 of 1

Criteria : Work Order ID: 156011 Item ID: D2500-1-190 Product Family SKIDTUBES
Work Order Start Dates 1/20/2017 to 1/20/2017 11:59:59 PM Work Order Required Dates 1/27/2017 to 1/27/2017 11:59:59 PM

Reference: SCRAPPED

Work Order Status Released

Work Order ID	156011	Required Qty	10.0000	Status Code	Released
Item ID	D2500-1-190	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Ext'n - 'I' Beam Tube 4"				
Current Acct Value	\$43.492				

Start Date	1/20/2017	Required Date	1/27/2017	Completed Date	
Rework	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$441.754	\$0.000	\$44.175	\$44.175	100.00%
Labor	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$441.754	\$0.000	\$44.175	\$44.175	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D2500-1-190					
Ext'n - 'I' Beam Tube 4"	10.0000		1/20/2017	10.0000	\$441.754
				Total Matl Amts:	\$441.754

151612

Should have 18 in stake!

Work Order ID 159717

159717

Page 1

Tuesday, April 18, 2017 11:27:44 AM

Item ID: D2500-1-190 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Ext'n - 1" Beam Tube 4"
 Start Date: 4/18/2017 Start Qty: 87.00 *87* Cust Item ID:
 Required Date: 5/17/2017 Req'd Qty: 87.00 *87* Customer:

Reference:

Approvals: Process Plan: APR 18 2017 Date: 13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2500	Rev H

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							

Purchasing
 Issue P/O: 36026
 a) Extrude as per Dwg D2500
 b) Material: 6061-T6 (QQ-A-200/8)
 c) Minimum yield tensile strength = 35 ksi
 d) Minimum ultimate tensile strength = 38 ksi
 e) Minimum elongation = 8%
 f) Order at 190" long
 g) Bon L Canada Inc. tool # 897105
 h) To be packed per DSK 066
 i) Pull test to ASTM standard B221 required.
 j) Material certification is required

110	Receive & Inspect for Damage & Mat'l Certs	0.00
110		
Packaging	Memo	1.74
Packaging	Ensure material certification is attached	

87 APR 20 2017 DAS 13 8-89

Uex SPT-5-21



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Monday, June 19, 2017

Details			
Raised Date 5/25/2017	Status Open	Owner Aboud, Robert	Number NCR17-6444
Target Date 6/23/2017	Standard ISO 9001:2008 / AS9100\7.0 Product Realization\7.4 Purchasing\7.4.3 Verification of purchased product		Severity MINOR
Process Inspection		Audit	
Raised By Person Duval, Patrick		Raised Against (Department or Supplier) Signature Aluminum Canada Inc.	Fault Category Material
Details During inspection of D2500-1-190 B159717 PO36026 some impressions where found throughout the tube, which in some case was also visible from the inside of the tube. 16 out of the 96 was found with those defect's			
Keywords		Product D205-634\D2500-1	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 6/2/2017	Owner Downing, Eric M	Closed Date 6/6/2017	Closed By Downing, Eric M
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	6/2/2017	6/6/2017
Perform a Root Cause Analysis an record all findings		see attached supplier response	

Corrective Action			
Target Date 6/23/2017	Owner Aboud, Robert	Closed Date 6/6/2017	Closed By Downing, Eric M
Details			